



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6405G06131-3G-1

Job Sheet 171604



Part No: RBW6405G06131-3G-1

Job Qty: 2 ea

Part Name: Reaction Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/5/18

Job Tracking No:

Due Date: 2/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6405G06131-3G Rev 3 IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/10/18	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	2 pcs		2/10/18	0.08	0.40	Large Fab 8		EL
110	QC	2 pcs		2/10/18	0.00	0.00	QC9		BF
121	Lathe Conv	2 pcs		2/12/18	0.00	0.20	Lathe Conv-1		15.1.1
122	QC	2 pcs		2/12/18	0.00	0.00	QC2 Machining-3		18/03/22
123	QC	2 pcs		2/12/18	0.00	0.00	QC8 Machining-2		18/03/22
130	Outsource	2 pcs		2/12/18	0.00	0.00	Outsource4		18/03/22
140	Packaging	2 pcs		2/12/18	0.00	0.00	Packaging2		18/03/22
150	QC	2 pcs		2/12/18	0.00	0.00	QC6		30
160	Packaging	2 pcs		2/12/18	0.00	0.00	Packaging3-2		9-89
170	QC21-SA	2 Ea		2/12/18	0.00	0.00	QC21		DAS 21

Part Op 100 - 1-Weld as per DWG Sheet 1. 2-Grind flush

Descriptions: 121 - 1-Bore-5 to final dim. as per DWG sheet4

130 - Issue P/O to ~~130~~ - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant - Certificate of Conformity is required

140 - Receive

160 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G06131-3G-3	Tube	2 Ea (1 ea)	90-Start up Operation	
RBW6405G06131-3G-5	Cap	2 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6405G06131-3G-3	2	0	0
	RBW6405G06131-3G-5	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____	Step #: _____	QTY Effective : _____			MRB (QS1042) Approval _____	

Description Work Order Deviation	Disposition

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Haverhill, ON K6A 1K7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 09/22/18

Root Cause		FAULT CATEGORY	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	



Container No: S053723



Part: RBW6405G06131 - 3G - 1

Job No: 171604

Serial No/Batch: S053723

Revision: 3

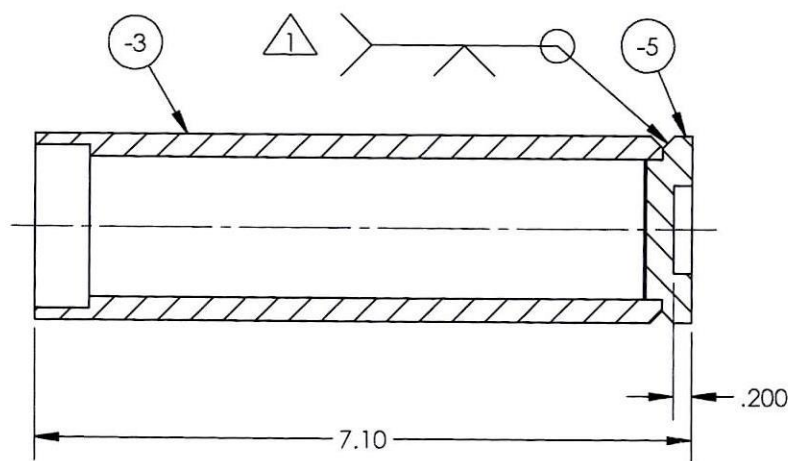
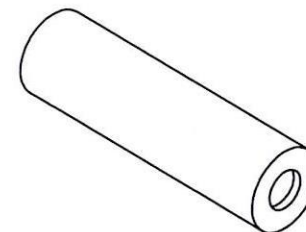
Inspector:

☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

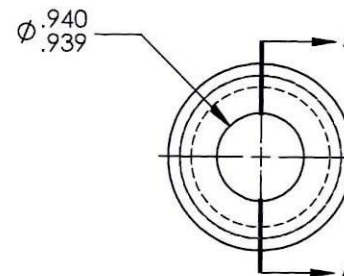
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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
3	16-0021	-1 ADDED DIMS Ø.939-.940, .200, ADDED CLEAN UP O.D. AFTER WELDING NOTE.			2/5/2016	DPD JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171604 180205



SECTION A-A



NOTE:

1 CLEAN UP O.D. AFTER WELDING.

(-1)
REACTION ASSY. WELDMENT

DART AEROSPACE	
TITLE REACTION ASSY.	
DWG NO. RBW6405G06131-3G-1	REV 3
MAT'L HEAT TREAT FINISH SPEC DRAWN BY: CHECKED: OPPS APPR: QA APPR: APPROVED:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL AGUSTA AW139
MIL-A-8625, TYPE II, CLASS I CLOUGH CLOUGH ANDERSON LINDSAY GILBERT	SCALE 1:2 DATE 3/19/2010 SHEET 2 OF 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039417

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039417
PO Date: 3/23/18
Due Date: 4/3/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171481	RBE703A94-1130-01-25	Tab Adjuster Handle -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water Seal - Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
2	171483	RBE703A94-1130-01-29	Tab Adjuster Clamp : URF 17-623 -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 - Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
3	171604	RBW6405G06131-3G-1	Reaction Weldment -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	4/3/18	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00
4	170608	RBE350A94-2706-00-09	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35

Plex 3/26/18 11:09 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(007845-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

007845- 2

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Mar-2018		Jessie Boisvert		039417				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE703A94-1130-01-25 Rev.	RBE703A94-1130-01-25 01 -ANO-CLEAR [ANODIZE CLEAR] MIL - A-8625FF TYPE 2 CLASS 1	ANODIZE CH	6	6	0	0	0
2	RBE703A94-1130-01-29 Rev.	RBE703A94-1130-01-29 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6	6	0	0	0
3	RBW6405G06131-3G-1 Rev.	RBW6405G06131-3G-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	2	2	0	0	0
9	RBE703A94-1130-01-11 Rev.	RBE703A94-1130-01-11 MIL-A-8625F TYPE 2 CLASS 1 CLEAR ANODIZE	ANODIZE CH	6	6	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.